

Work Order ID 69559

Thursday, May 12, 2011 8:32:48 AM



Ship today

Page 1

Item ID: D3575-2

Accept



Setup Start



Revision ID:

Item Name: Cabin Floor Protector

Stop



Start Date: 5/12/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: MEDate: 11-05-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3575

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3575 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessaryB11-5-12(2)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-5-12

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sub 5/12(2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69559

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Page 2

Item ID: D3575-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 5/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

SB 11/05/12

(2)

Small Fab

Deburr if necessary.

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

8 11/05/12

(2)

Quality Control

150



Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

11/5/12 SD (2)

Packaging

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69559

Thursday, May 12, 2011 8:32:48 AM



Page 3

Item ID: D3575-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 5/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/12 [Signature]
MF
11-05-12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 12, 2011 8:32:46 AM

Page 1

Work Order ID: 69559

Parent Item: D3575-2

Parent Item Name: Cabin Floor Protector



Start Date: 5/12/2011

Required Date: 5/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.125-F60029-04

Purchased

No

100

sf

1,826.215

10.666

11.22737



1B11-5-17

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT018

1826.215789

116236

1826.21579

116236

②

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

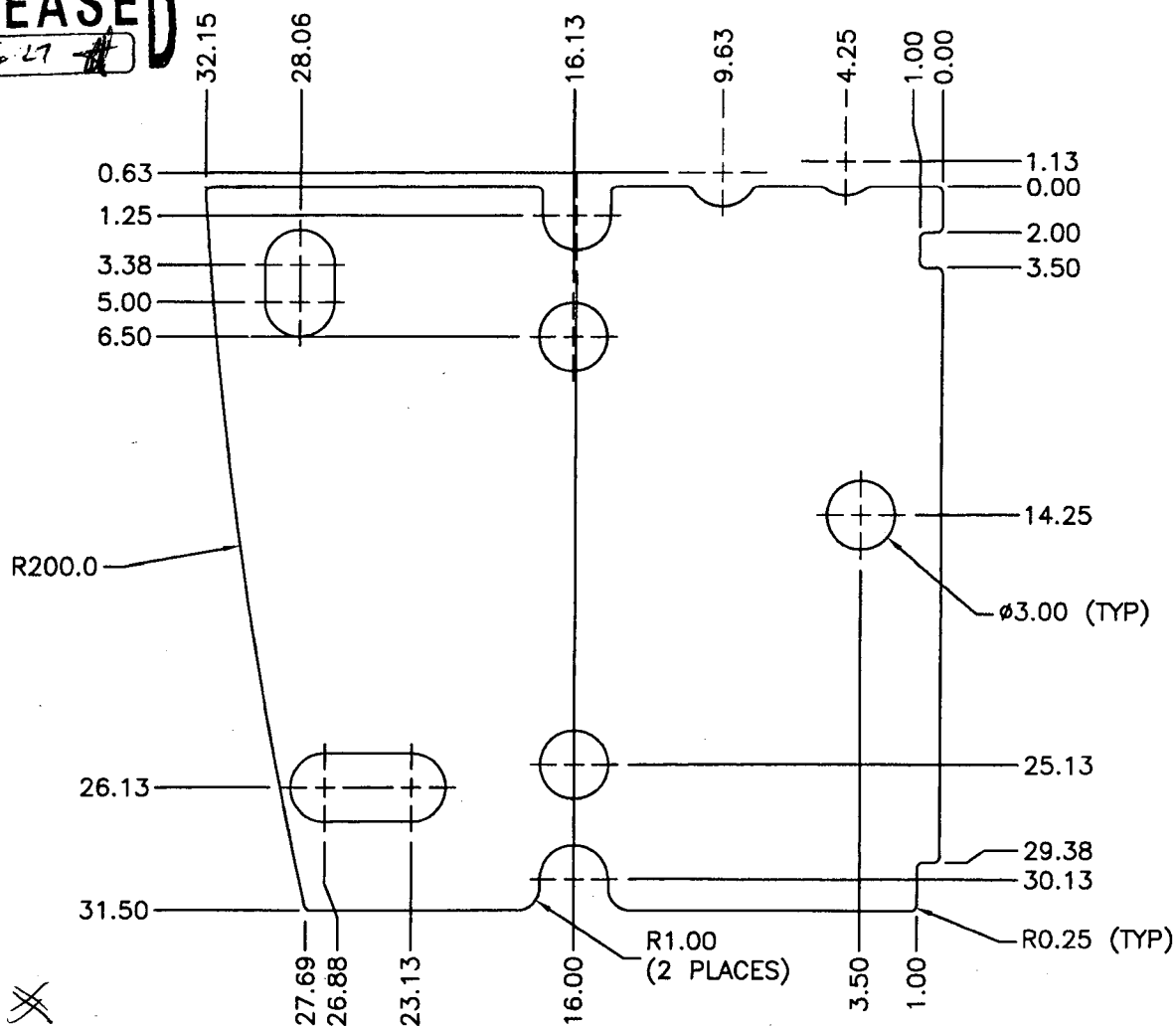
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>#</i>	DRAWING NO. D3575	REV. A SHEET 1 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8
A	07.06.08	NEW ISSUE	

RELEASED
07.06.08 *#*

D3575-1 CABIN FLOOR PROTECTOR (SHOWN)
D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	69559
Description: Cabin Floor Protector		Part Number:	D3575-2
Inspection Dwg: D3575	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.001	x		V B02	
1.00	+/-0.030	1.06	x		T B01	
3.50	+/-0.030	3.50	2		T	
16.00	+/-0.030	16.00	2		T	
23.13	+/-0.030	23.13	2		T	
26.88	+/-0.030	26.88	2		T	
27.69	+/-0.030	27.69	2		T	
4.25	+/-0.030	4.25	2		T	
9.63	+/-0.030	9.63	2		T	
16.13	+/-0.030	16.13	2		T	
28.06	+/-0.030	28.06	2		T	
32.15	+/-0.030	32.15	2		T	
2.00	+/-0.030	2.00	2		T	
3.50	+/-0.030	3.50	2		T	
14.25	+/-0.030	14.25	2		T	
25.13	+/-0.030	25.13	2		T	
29.38	+/-0.030	29.38	2		T	
30.13	+/-0.030	30.13	2		T	
1.25	+/-0.030	1.25	2		T	
3.38	+/-0.030	3.38	2		T	
5.00	+/-0.030	5.00	2		T	
6.50	+/-0.030	6.50	2		T	
26.13	+/-0.030	26.13	2		T	
31.50	+/-0.030	31.50	2		T	

Measured by: RB	Audited by: J	Prototype Approval:	N/A
Date: 11-5-12	Date: 11/05/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/DD	